

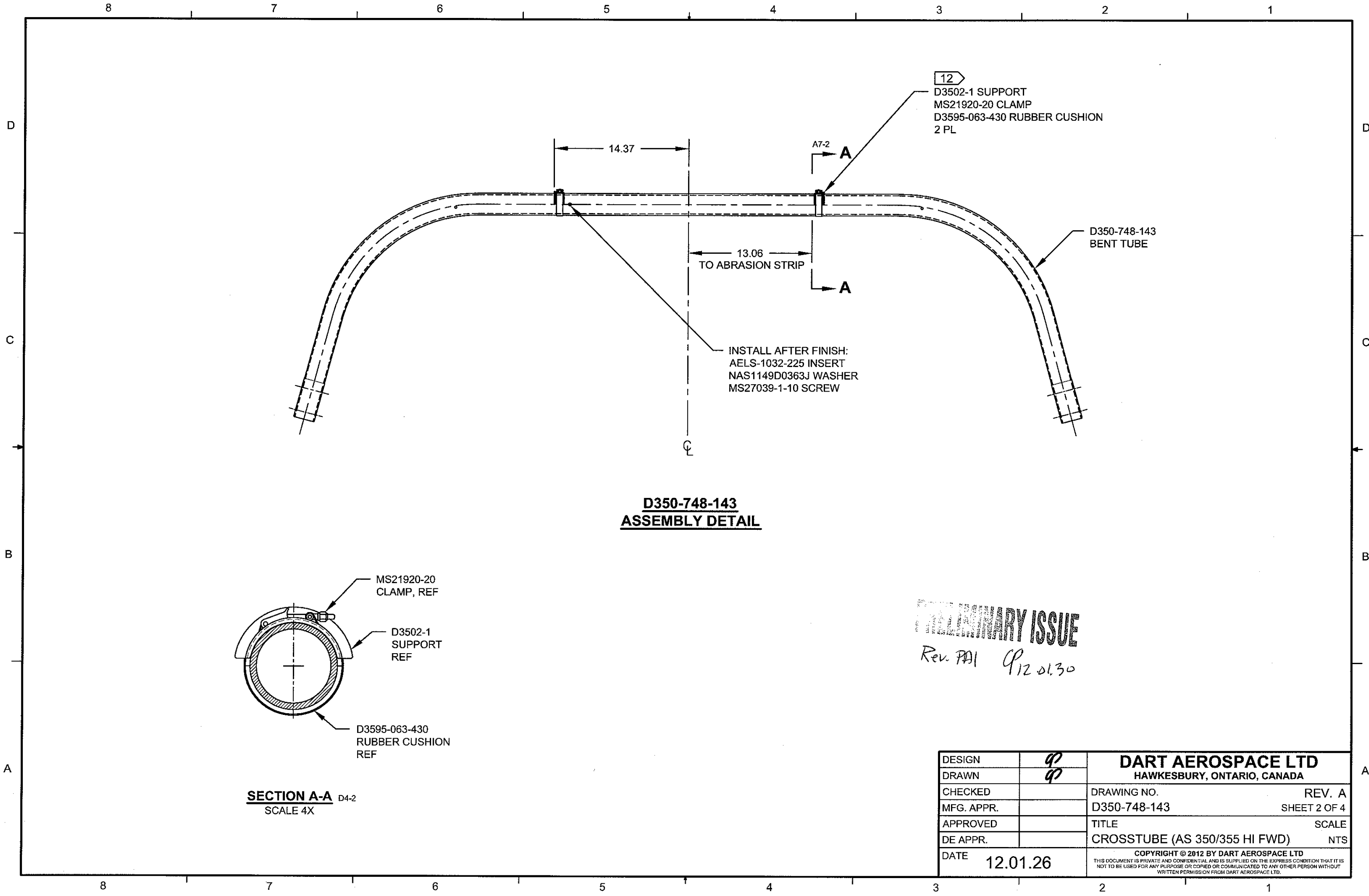
Item	Qty -143	Part Number	Description
1	X	D350-748-143	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
2	1	D6021-125	CROSSTUBE
3	2	D3502-1	SUPPORT
4	2	D3595-063-430	RUBBER CUSHION
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

GENERAL NOTES:

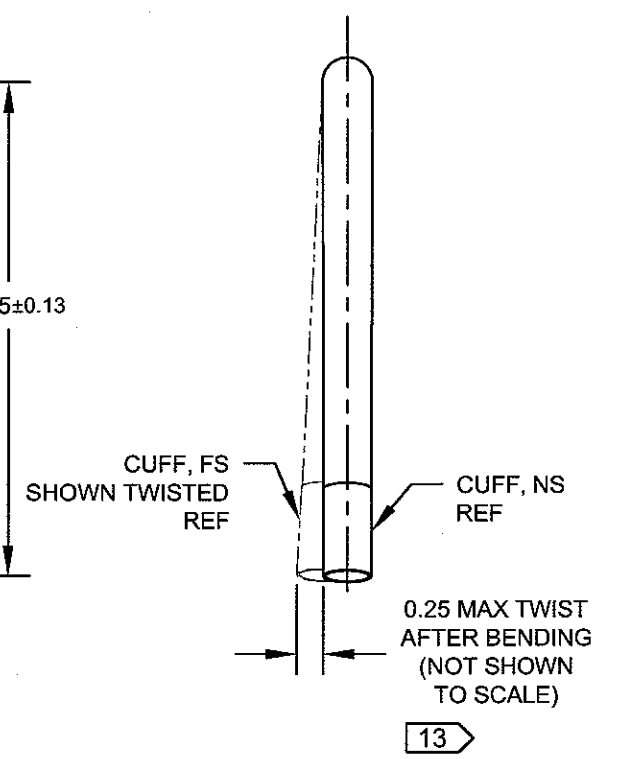
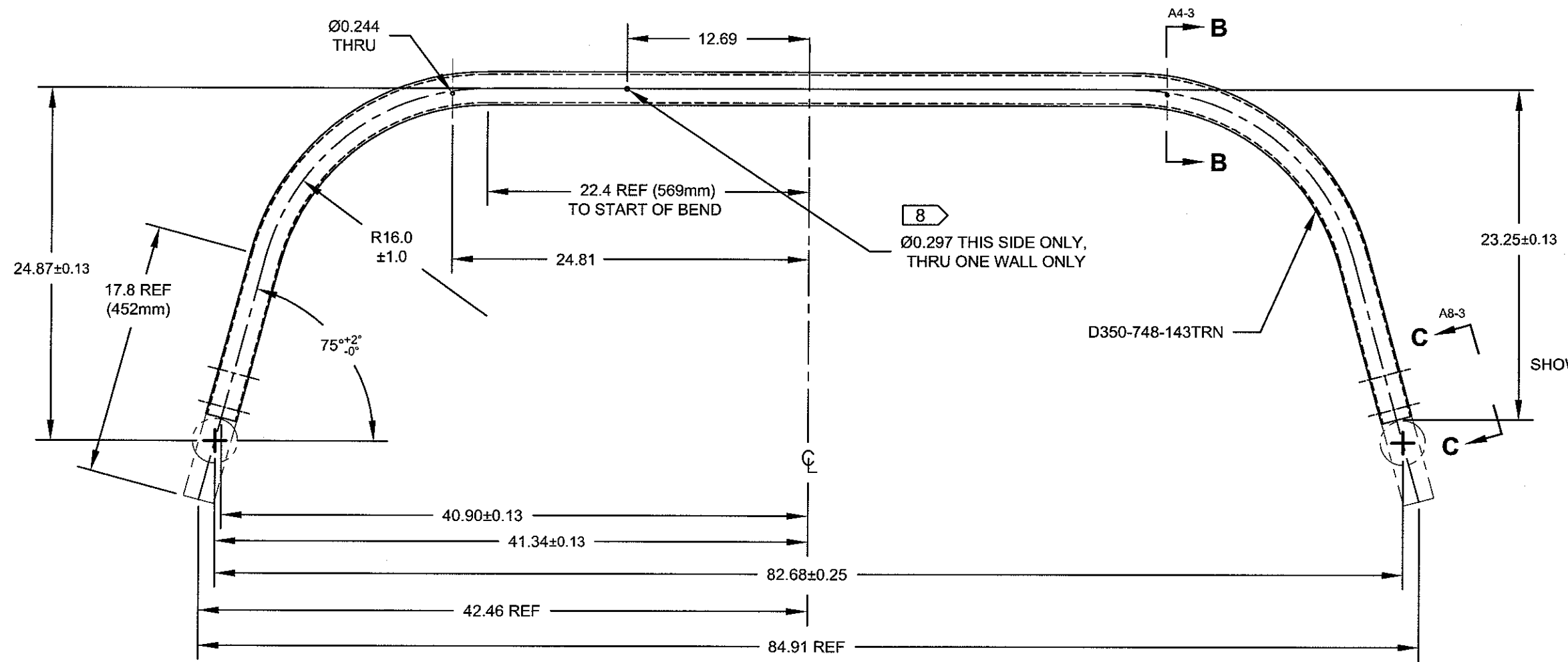
- 1) MATERIAL: MANUFACTURED FROM D6021-125 (17-4PH)
FINISHED LENGTH = 122.270±0.06
- 2) FINISH: PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: DART PART NUMBER "D350-748-143" AND BATCH NUMBER ON INSIDE OF CUFF
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 30.45 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- 9) BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO
BENDING IS 6% BASED ON O.D.
- 11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES,
NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY.
CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE
MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO
CRACKING/CHIPPING/GROOVES.
- 12) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT
NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 13) MAX TWIST AFTER BENDING: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN
CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.25 (ZN C1-3).

PRELIMINARY ISSUE
Rev. PA1 12.01.30

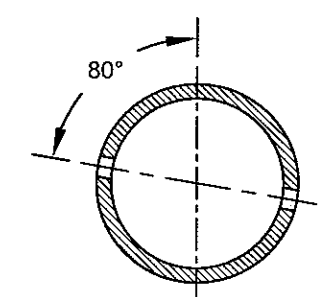
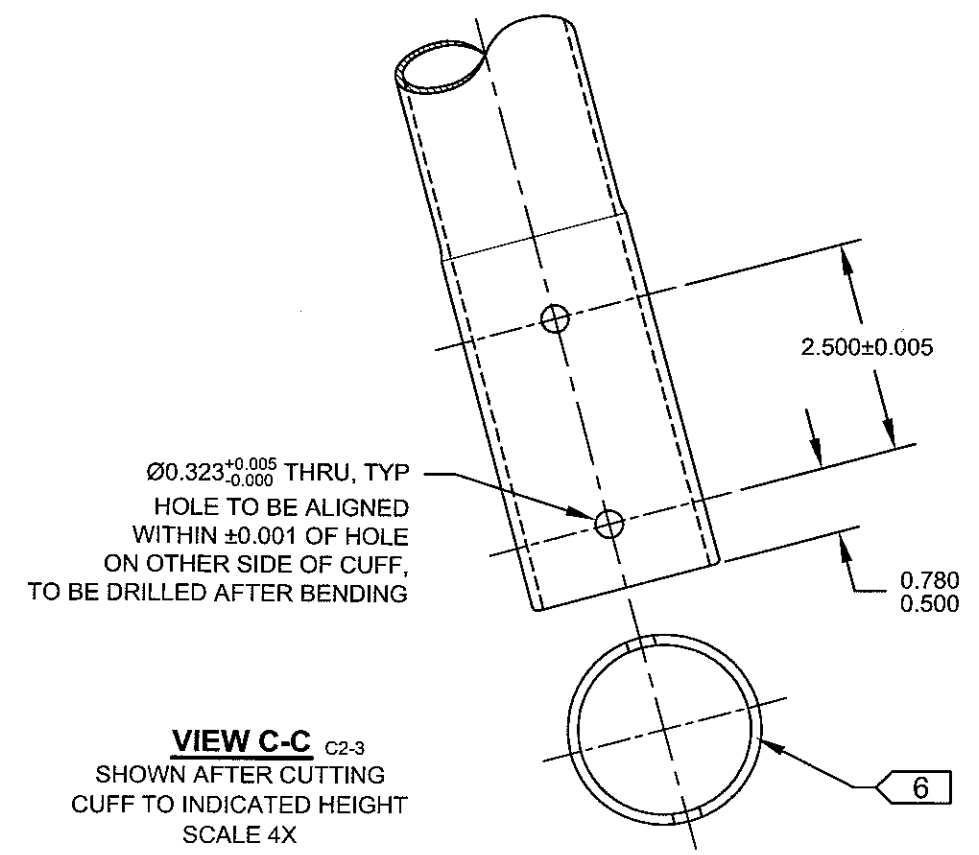
PA1	NEW ISSUE		CP	12.01.26
REV.	DESCRIPTION		BY	DATE
DESIGN	QP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	QP			
CHECKED		DRAWING NO.	REV. X	
MFG. APPR.		D350-748-143	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		CROSSTUBE (AS 350/355 HI FWD)	NTS	
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DRAWN	qp		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D350-748-143	SHEET 2 OF 4
APPROVED		TITLE	SCALE
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D350-748-143
BENDING AND DRILLING DETAIL 10



SECTION B-B D3-3
 SCALE 4X

PRELIMINARY ISSUE
 Rev. PA1 12.01.26

DESIGN	qp	DART AEROSPACE LTD	
DRAWN	qp	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D350-748-143	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE (AS 350/355 HI FWD)	NTS
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